

1: 5/12 W/O SPLIT

DART AEROSPACE LTD		Work Order:	22466A
Description: Lock Shaft (R44)		Part Number:	D3357-5
Dwg: D3357 Rev. A page 3		Qty:	20 2
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HJ	05.02.16	5
2	MC	Turn as per Folio FA505 and Dwg D3357 Material: AISI 303 SS Round Bar 1.00" (M303R1.000) Identify for D3357-5	SA	05.04.06	2
3	QC2	Inspect parts as they come off the CNC machine Identify as D3357-5	SA	05.04.06	2
4	QC8	Second check	BE	05.04.06	2
5	MC	Deburr	SA	05.04.06	2
6	QC5	Inspect work to Step 5	BE	05.04.06	2
7	ST	Identify and Stock	CA	05.04.06	2
8	AC	Cost / part 21.91	SA	05.04.07	2
9	DC	Close W/O 21.91 Inspect Level 21	HJ	05.04.07	2

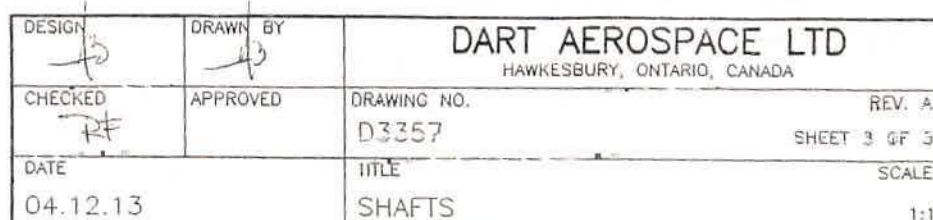
PTU

Rev	Date	Change	Revised By	Approved
A	05.02.03	New issue	KJ/JLM	

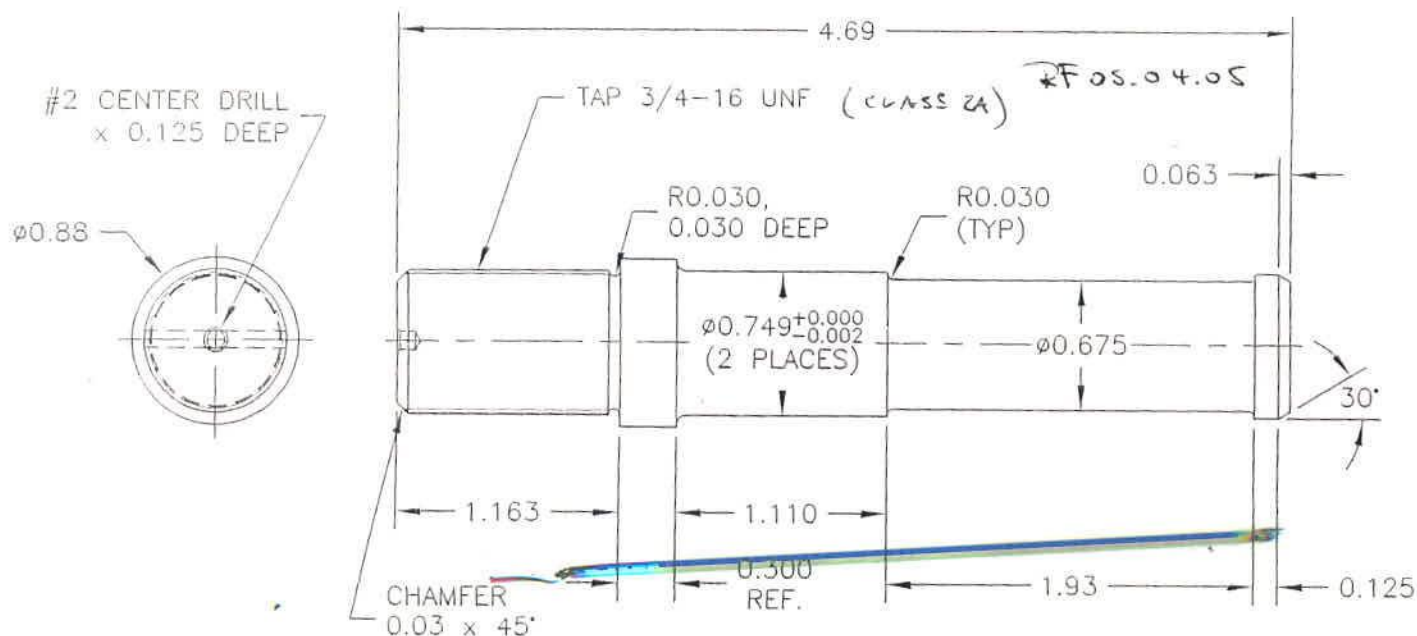
PRELIMINARY ISSUE

M304R1.00
M17002

M304R1.000
M17002



PRELIMINARY ISSUE

$$\begin{aligned} & \pi = 2.819 \\ & z = 4.556 \\ \text{Fin} &= \pi = 0.616 \\ & z = 4.760 \end{aligned}$$


SHOP COPY
RETURN TO
ENGINEERING

D3357-5 R44 LOCK SHAFT

NOTES:

1) MATERIAL: AISI 303 ROUND BAR STAINLESS STEEL
(REF. DART SPEC. M303R1.000)

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE INCHES

4) BREAK ALL SHARP EDGES 0.005 TO 0.010

22466

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 15, 2005
03:37 pm

Work Order No : 0022466
Project Name : D3357-5
Project For : WK512
Work Order Type : Main
Main WO Number :
House Part Number : D3357-5
Description : Lock Shaft R44
Manufactured : Yes
Amount Req'd : *2*
Amount Done : 0
Start Date :
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00	0.00	0.00
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00	0.00	0.00
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Work Order: 22466
Part Number: 03357-3
Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

	Reference	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.64	±.030	4.698	✓			
1.163	±.010	1.163	✓			
.300		.303	✓			
1.110	±.010	1.109	✓			
1.93	±.030	1.928	✓			
125	±.010	117	✓			
30°		30°	✓			
.063	±.010	.073	✓			
Ø.675		Ø.679	✓			
Ø.749	+0.000 -0.002	Ø.7485	✓			
Ø.88	±.030	.894	✓			
						REMOVE SHARP EDGE AS PER DWG

ist
05.03.06

Audited by: ml	Prototype Approval: RT
Date: 05/04/06	Date: 05.04.06

Revised by: KJ/JLM	Approved:
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